

Date: Monday, 6/25/2007 9:10:37 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services *W* Drawing Name : DOOR ASSEMBLY  
 Job Number : 33121  
 Estimate Number : 10713  
 P.O. Number :  
 This Issue : 6/25/2007 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : SMALL / MED FAB  
 Previous Run : 31659  
 Written By :  
 Checked & Approved By : *[Signature]*  
 Comment : Est Rev: A New Issue 05-11-17 17:27

Part Number : D3213041  
 Drawing Number : D3213 REV A  
 Project Number : N/A  
 Drawing Revision : A  
 Material :  
 Due Date : 7/12/2007 Qty: 20 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D31613 Hinge 15.0"



Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch  
 2 D3161-3 Hinge *B 33189* *x20*

*B 33189*

*FF 07/08/16 20*

2.0 D32131 Door Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch  
 1 D3213-1 Door *B 33119*

*FF 07/08/16 20*

3.0 D32133 Door Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch  
 1 D3213-3 Door *B 33120*

*FF 07/08/16 20*

4.0 MS20470AD44 Rivet, Universal Head



Comment: Qty.: 24.0000 Each(s)/Unit Total: 480.0000 Each(s)


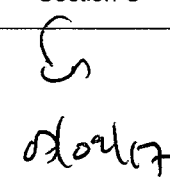

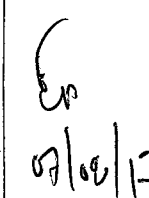
Pick: Assembly Kit

Qty Part Number Description Batch  
 24 MS20470AD4-4 Rivet *M105125* *4242*

*M104885 x 56 FF 07-09-14 20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3213-041 PAR #: N/A Fault Category: Prod / Ins. Ass. - med & small NCR: Yes No DQA: D Date: 07/10/07  
 QA: N/C Closed: Yes Date: 07.12.07

NCR: 33121		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-08-17	1.0 # and #5.0	1 D3161-3 Hinge Drilled starting hole on wrong side  R.C Human Error have Hinge <del>upside</del> Down		scrap & Replace by new one <u>B# 34038</u>	FF 07-08-17			

NOTE: Date & initial all entries

Date: Monday, 6/25/2007 9:10:38 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 33121

Part Number: D3213041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3213 Identify as D3213-041

FF 07-09-14 20

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er Abel 18 counter x20

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-L 07/09/19

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf 07-10-01

9.0

D2137

Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 D2137 Decal

B31463

24

B33184

10.0

D2419

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 D2419 Handle

B33186

EP

11.0

D2462

Neoprene Seal



Comment: Qty.: 2.4000 f(s)/Unit Total: 48.0000 f(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

2 D2462

Seal

B29456

EP

EP 07/09/19 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 6/25/2007 9:10:38 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 33121

Part Number: D3213041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D27281

Dart Logo label small



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2728-1 Decal B24215

13.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 AN960JD6 Washer M16085

14.0

MS20470AD46

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 MS20470AD4-6 Rivet M104118

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3213

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3213-041 PAR #: N/A Fault Category: Prod/FAB. ASS <sup>MFD & Small</sup> NCR: Yes No DQA: D Date: 07/10/04  
 QA: N/C Closed: HA Date: 07.10.04

NCR: <u>33121</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/04	#15	<del>one</del> one Rivet was installed wrong. R.C. Humman error	<i>[Signature]</i>	Remove Rivet. when Rivet was removed the hole was found to be oval sized. Drill to $\phi$ .155 <del>size</del> .	MF 07-10-02	<i>[Signature]</i> 07/10/02	<i>[Signature]</i> 07/10/02	<i>[Signature]</i> 07-10-02
	#15	u	<i>[Signature]</i>	and install rivet to MS 20470A1056 # M 2421 WASHER: AN960JDIOL M101340.	MF 07-10-02	<i>[Signature]</i> 07/10/02	<i>[Signature]</i> 07/10/02	<i>[Signature]</i> 07-10-02

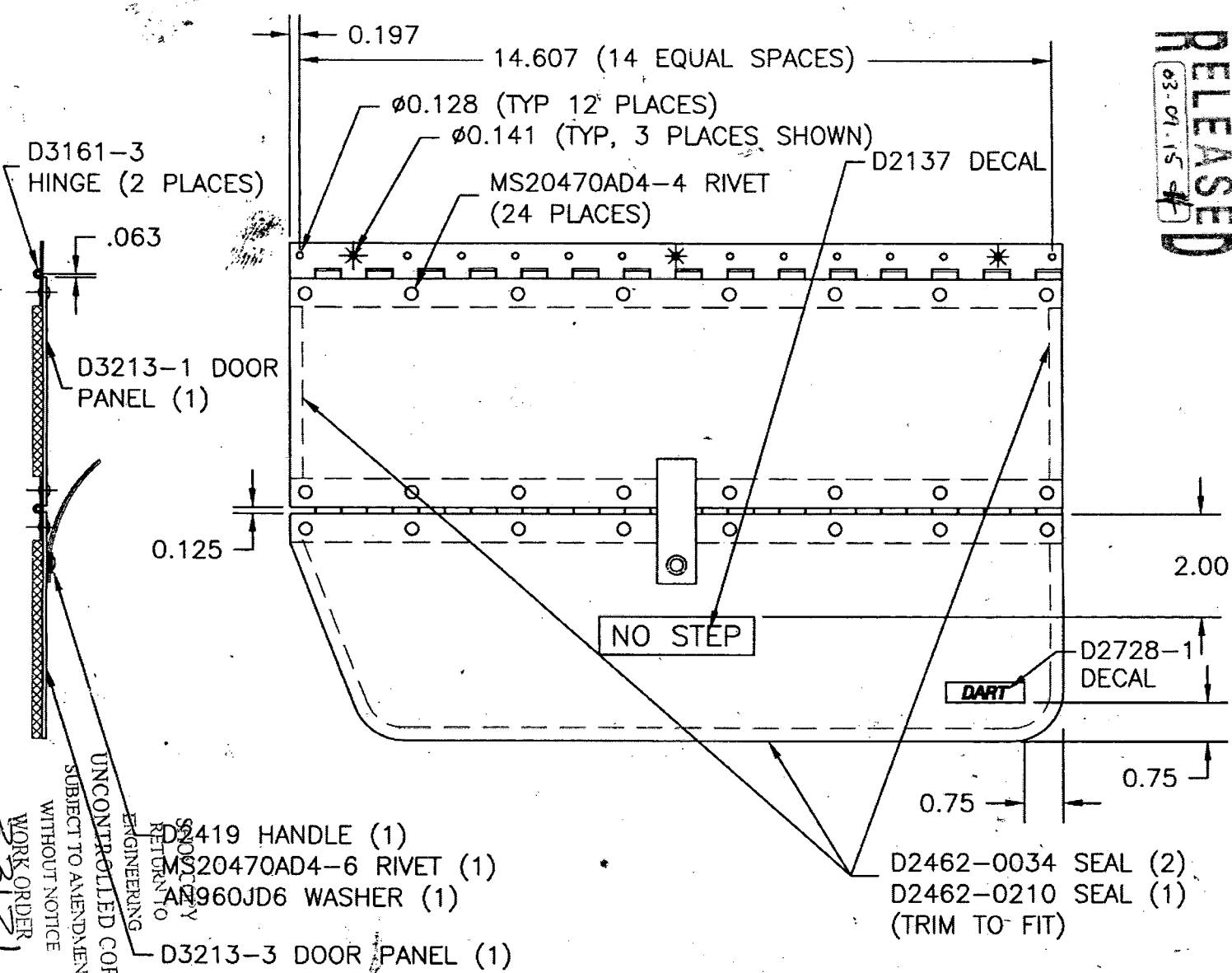
NOTE: Date & initial all entries

**DART**

QA COPIES USED

RELEASED  
03-01-15

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3213
DATE 03.09.03	TITLE DOOR ASSEMBLY	REV. A 1 OF 2
A	03.09.03	SCALE 1:3
	NEW ISSUE	



UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 33121

**D3213-041 DOOR ASSEMBLY**

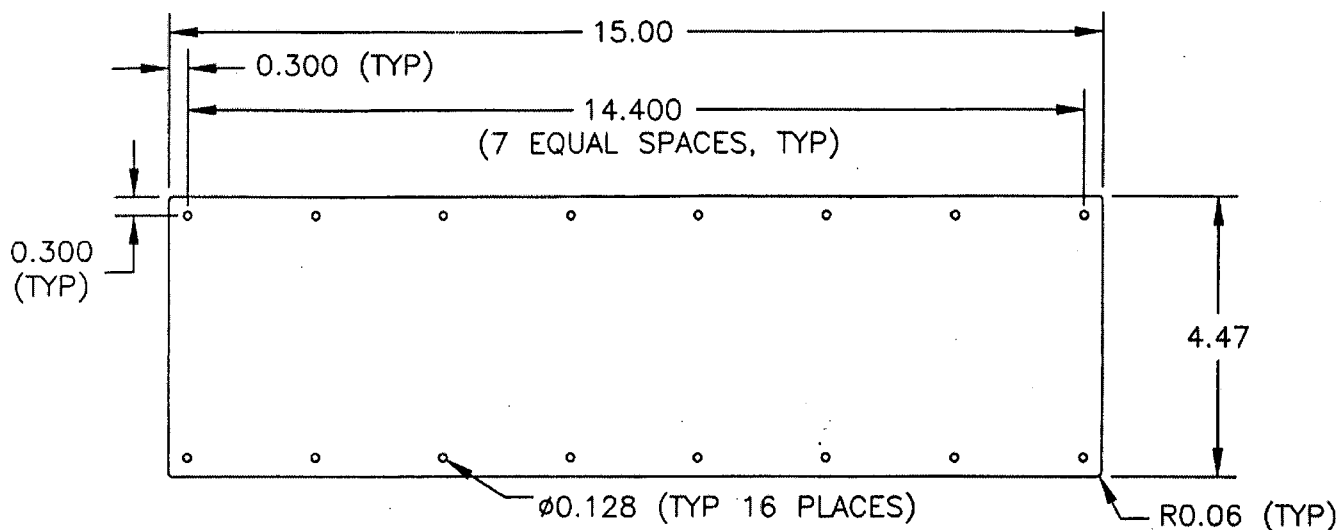
FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE  
FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3  
INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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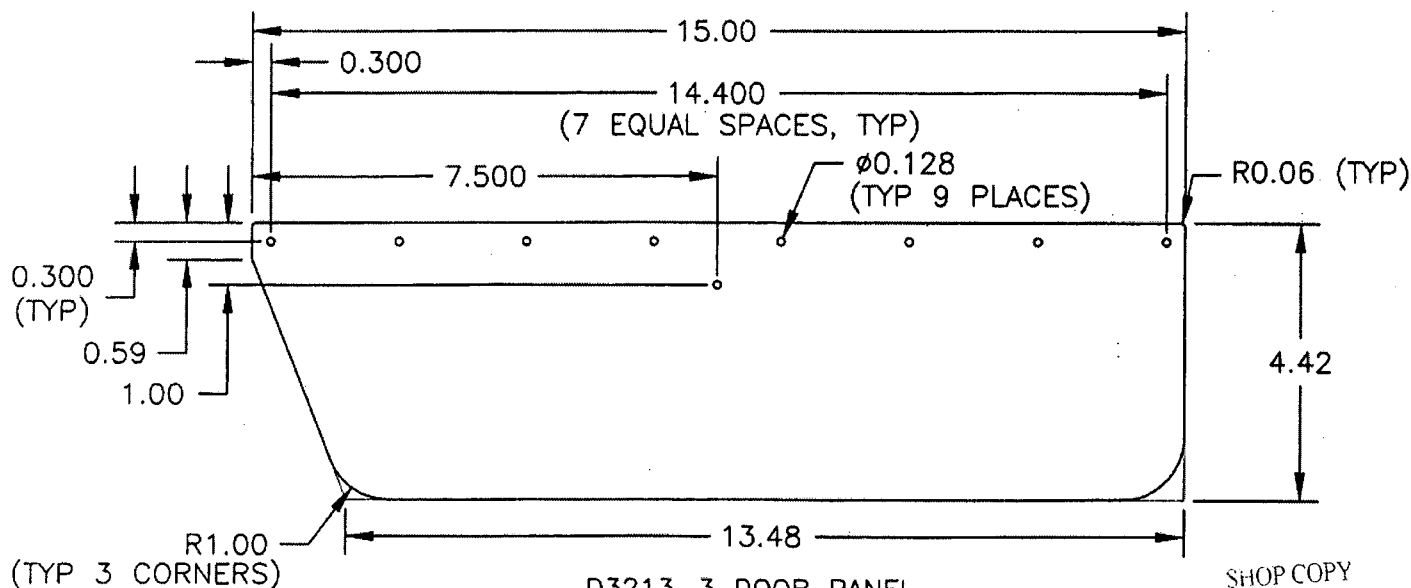
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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3213	REV. A 2 OF 2
DATE 03.09.03		TITLE DOOR ASSEMBLY	SCALE 1:3



D3213-1 DOOR PANEL



D3213-3 DOOR PANEL

D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
03.09.15  
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WORK ORDER  
NO. 33121

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ENGINEERING

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